

Date: Tuesday, 9/19/2006 2:13:51 PM  
 User: Kim Johnston

## Process Sheet

<b>Customer</b> : CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b> : BASKET BASE ASSEMBLY EC 130
<b>Job Number</b> : 28650B	
<b>Estimate Number</b> : 10814	
<b>P.O. Number</b> : N/A	<b>Part Number</b> : D3172041
<b>This Issue</b> : 9/19/2006 <b>S.O. No.</b> : N/A	<b>Drawing Number</b> : D3172 REV B
<b>Prsht Rev.</b> : NC	<b>Project Number</b> : N/A
<b>First Issue</b> : N/A <b>Type</b> : LARGE FAB ASSY	<b>Drawing Revision</b> : B
<b>Previous Run</b> : 24836B	<b>Material</b> : N/A
<b>Written By</b> : <u>[Signature]</u>	<b>Due Date</b> : 9/26/2006 <b>Qty:</b> 1 <b>Um:</b> Each
<b>Checked &amp; Approved By</b> : <u>[Signature]</u> 06.09.19	
<b>Comment</b> : Est Rev:B 04.01.05 Added Step 5 inspection KJ/RF	

## Additional Product

Job Number:



<b>Seq. #:</b>	<b>Machine Or Operation:</b>	<b>Description :</b>
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1.0	D31661	Basket Hoop
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**Comment:** Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty 4 D3166-1 Basket Hoop Batch: B28094

06/09/19

2.0	M304TS0750W065	304 SQ Tube.75x.75x.065W
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**Comment:** Qty.: 42.0000 f(s)/Unit Total : 42.0000 f(s)  
 3/4" x 3/4" square tubing as per Dwg D3266Material: 304/316 SS tube .063" wall(  
 M304TS0.750W.065)  
 Batch: M102040

06/09/19

3.0	D2012117	Clevis
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**Comment:** Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

2 D2012-117

Clevis B16369

06/09/19

4.0	D22323	Basket Hinge
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**Comment:** Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

2 D2232-3

Hinge plate

B24527

06/09/19

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
2009-21	3	2 instead of 4 perm. chg	L			Le	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 9/19/2006 2:13:51 PM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BASKET BASE ASSEMBLY EC 130

Job Number: 28650B

Part Number: D3172041

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

D23273

Spacer Bushing



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

2 D2327-3

Bushing

B28073

*MA 06/09/19*

6.0

D31741

Mounting Lug



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

8 D3174-1

Mounting Lug

B24882

*MA 06/09/19*

7.0

D2581

Mounting Bracket



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

2 D2581

Mounting Bracket

B27587

*MA 06/09/19*

8.0

M304EX07516F

Expanded Metal Flat Stai



Comment: Qty.: 48.0000 sf(s)/Unit Total : 48.0000 sf(s)

Pick:

Qty Part Number

Description

Batch

48sf M304EX0.75-16F

Expanded Metal

M102126

*MA 06/09/22*

9.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Cut Qty 4 D3166-1 as per Dwg D3172

2-Cut 3/4" x 3/4" square tubing as per Dwg D3172

3-Drill holes in D3172-3 as per Dwg D3172

*MA 06/09/25*

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
06/09/26		Applied Sikaflex before putting rivets (after drilling). 3 M10/853 Exp: 02/0007	MF	06/09/26				

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA: ☒ Date: 06/09/26  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 9/19/2006 2:13:52 PM  
User: Kim Johnston

# Process Sheet

SHP Wed 27/09

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BASKET BASE ASSEMBLY EC 130

Job Number: 28650B

Part Number: D3172041

Job Number:



Seq. #:

Machine Or Operation:

Description :

4-Deburr & Remove all markings from material

5-Weld as per Dwg D3172 using Welding Table and corner Jig & D3172T1 Deburr as required

A/R SS Rod Batch M101244

1106/09/25

10.0

QC9/6

DDIMENSIONAL & WELDING INSPECTION



Comment: DDIMENSIONAL & WELDING INSPECTION

Inspect D3174-1 mounting lugs line up with DT8715 Jig to reflect D3177-041/-043 bracket leg distance as per Dwg IIN-D130-701

PD 06-09-25 (1)

11.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI-005 4.3

Y.L

A.M

06-09-26

(6)

12.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: Inspect Powder Coat

MF.

06/09/26

(1)

13.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: G.A.

MF.

06/09/26

(1)

14.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

MF.

06/09/26

(1)

Job Completion



11 06-09-26

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

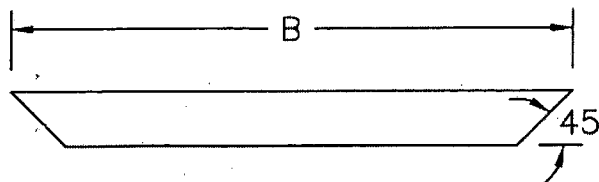
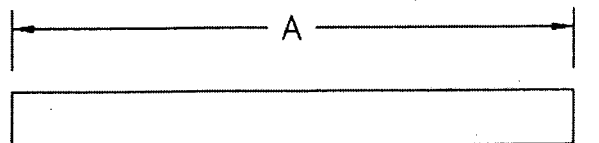


DESIGN #	DRAWN BY CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D3172	REV. B SHEET 1 OF 3
DATE 03.01.07		TITLE BASKET BASE ASSEMBLY (EC130)	SCALE NTS
A	02.12.02	NEW ISSUE	
B	03.01.07	ADD D3172-9 & D2012-117	

RELEASED  
03.01.20 #

PARTS LIST FOR D3172-041 BASKET BASE ASSEMBLY

PART NO	QUANTITY	LENGTH A	LENGTH B	DESCRIPTION
D3172-1	2	—	96.00	RIB
D3172-3	2	—	25.50	RIB
D3172-5	6	33.09	—	RIB
D3172-7	3	26.81	—	RIB
D3172-9	1	94.50	—	RIB
D2012-117	4	N/A	N/A	CLEVIS
D2327-3	2	N/A	N/A	BUSHING
D2581	2	N/A	N/A	MOUNTING BRKT
D2232-3	2	N/A	N/A	HINGE PLATE
D3166-1	4	N/A	N/A	RIB
D3174-1	8	N/A	N/A	MOUNTING LUG



NOTES:

- 1) CUT LENGTH/SHAPE PER DIAGRAM AND PARTS LIST
- 2) FRAME MATERIAL: AISI 304/316 SS, 3/4 X 3/4 X 0.060 WALL SQUARE TUBING
- 3) MESH MATERIAL: 3/4-16F EXPANDED SS
- 4) WELD PER DART QSI 004
- 5) FINISH: POWDER COAT ENTIRE ASSEMBLY WHITE (4.3.5.2) PER DART QSI 005 4.3
- 6) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 7) ALL DIMENSIONS ARE IN INCHES

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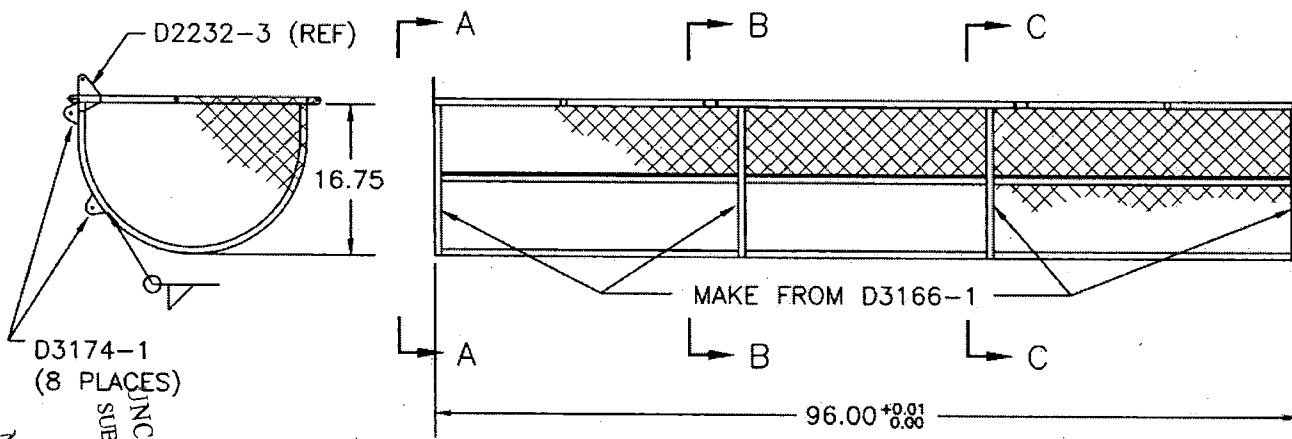
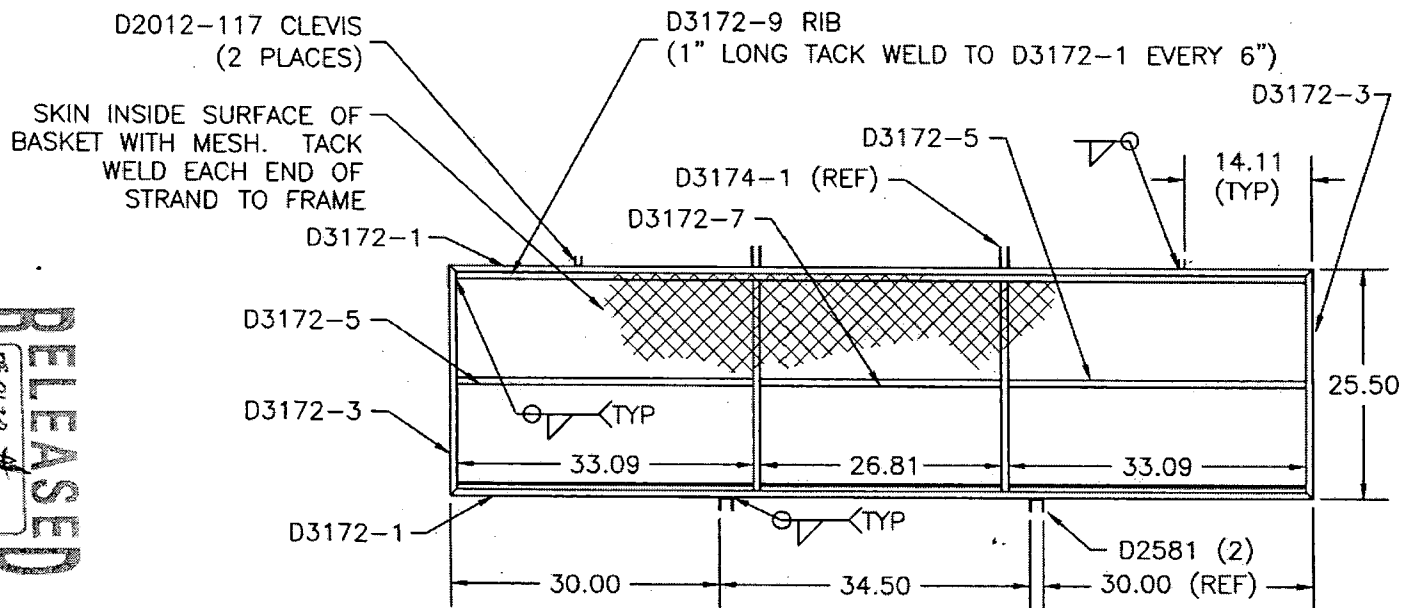
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**DART**



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DATE	DRAWING NO.	REV. B
03.01.07	D3172	SHEET 2 OF 3
	TITLE	SCALE
	BASKET BASE ASSEMBLY (EC130)	1:20



D3172-041 BASKET BASE ASSEMBLY

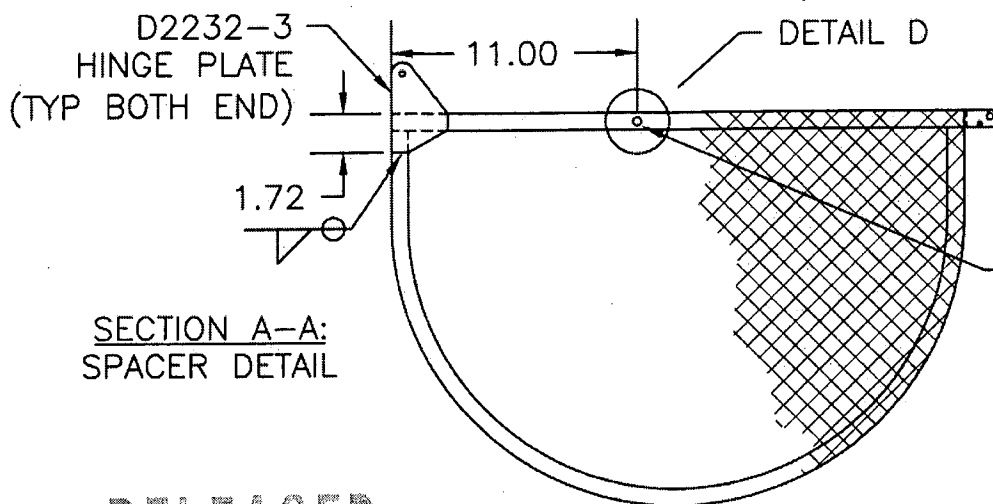
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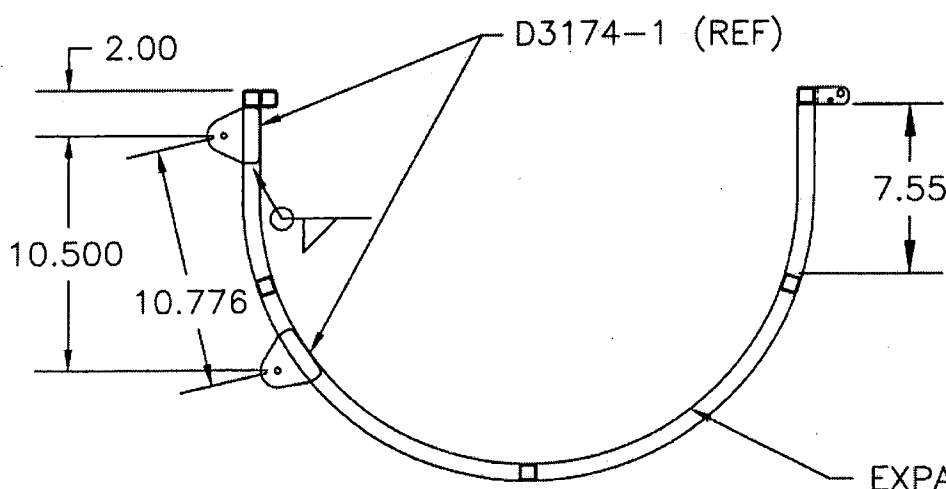
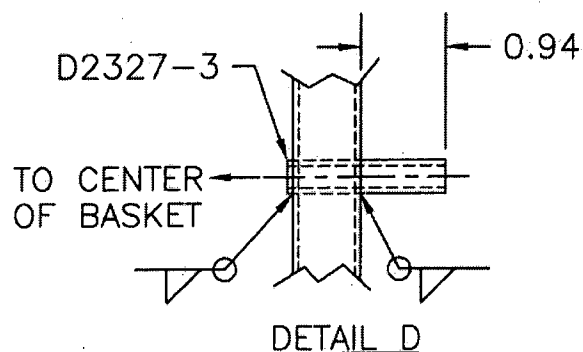




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CHECKED	APPROVED	DRAWING NO. D3172	REV. B SHEET 3 OF 3
DATE 03.01.07		TITLE BASKET BASE ASSEMBLY (EC130)	SCALE 1:8



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03.01.20



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